



# Work Order ID 60305 - 1

Thursday, July 01, 2010 1:10:18 PM






Page 1

Item ID: D3319-3 *Split 3* Accept  Setup Start   
 Revision ID:   
 Item Name: Wearplate Stop   
 Start Date: 7/1/2010 Start Qty: 6.00  Cust Item ID:   
 Required Date: 7/8/2010 Req'd Qty: 6.00  Customer:   
 Reference:

Approvals: Process Plan: *16-7-9* Date: *10-7-9* Tooling: Date:   
 QC: Date: SPC (Y/N): Date:   
 Run Start    
 Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3319	Rev B

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3319 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary	0.00							
			<i>=&gt; m-d 10/07/06 (6x)</i>						
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
			<i>m-l 10 07 06 (6)</i>						
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							
			<i>8 10/07/06 (x6)</i>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60305

Thursday, July 01, 2010 1:10:18 PM



Page 2

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

0.00

Small Fab

Memo

Deburr if necessary

*ultra 5*

Small Fab

140

0.00



NC BRAKE

0.00

Brake NC

Memo

Form using DT8326 & DT8261 as per Dwg D3319Rev:

*B SD 10/07/04*

*(6)*

Brake NC

150

0.00



QC6- Inspect dimensions to drawing

0.00

QC

Memo

*Selox*

*(6)*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Item ID: D3319-3

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Large Fab

Large Fab

Memo

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev:

☐ Qty Part Number Description Batch ☐ A/R

N/A 7560 Hardcoat Rod

M112507

EL 10-8-12 (X6)

170

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

Siolos12

180

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Siolos12

(X6)

W/O:		WORK ORDER CHANGES					
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Thursday, July 01, 2010 1:10:18 PM



Page 4

Item ID: D3319-3

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Memo 11/2588

0.00

Powder Coating

START TIME: 1:00  
3:00 FINISH TIME:

OVEN TEMPERATURE:

1:30

6 BR 10-8-23

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M 10/08/23

x6 6

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3319-3, B/N: BXXXXX ☐For Product Eligibility see PDA05-18 ☐and Stock ☐Location: 497

10/12/24 4/60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 60305**

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Page 5

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Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 6.00



Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/24

C21018124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 01, 2010 1:10:25 PM

Page 1

Work Order ID: 60305

Parent Item: D3319-3

Parent Item Name: Wearplate




Start Date: 7/1/2010

Required Date: 7/8/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM ☐  
IPP Rev:B Now on Waterjet 06-10-03 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA  1010/1025 SHEET .048		Purchased	No			100	sf	61.0000	3.2524	20.54147			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT19	61						
						<u>114225</u>	61						

*mm* 10-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	40305
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	✓		M.T	
74.420	+/-0.010	74.420	✓		M.T	
62.770	+/-0.010	62.770	✓		M.T	
52.890	+/-0.010	52.890	✓		M.T	
30.790	+/-0.010	30.790	✓		M.T	
8.690	+/-0.010	8.690	✓		M.T	
0.60	+/-0.030	0.601	✓		VWV	
2.690	+/-0.010	2.697	✓		VWV	
2.940	+/-0.010	2.945	✓		VWV	
3.527	+/-0.010	3.526	✓		VWV	
4.518	+/-0.010	4.514	✓		VWV	
Ø0.190	+0.005/-0.001	0.191	✓		VWV	
2.940	+/-0.010	2.945	✓		VWV	
2.940	+/-0.010	2.945	✓		VWV	
2.690	+/-0.010	2.695	✓		VWV	
5.063	+/-0.010	5.064	✓		VWV	
6.163	+/-0.010	6.163	✓		M.T	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	0.317x.607	✓		VWV	
0.048	+/-0.010	0.049	✓		VWV	

Measured by: <i>MM. M</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 10.07.06	Date: 10/07/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM <i>AJ</i>	<i>EE</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

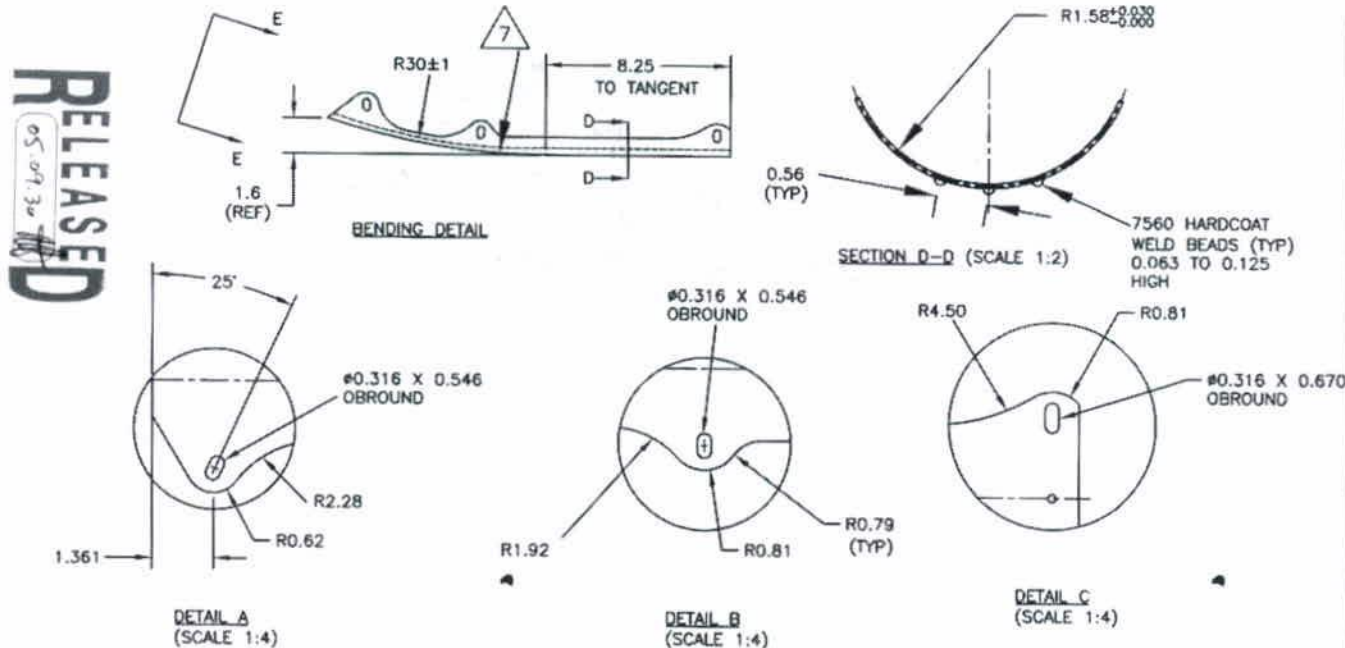
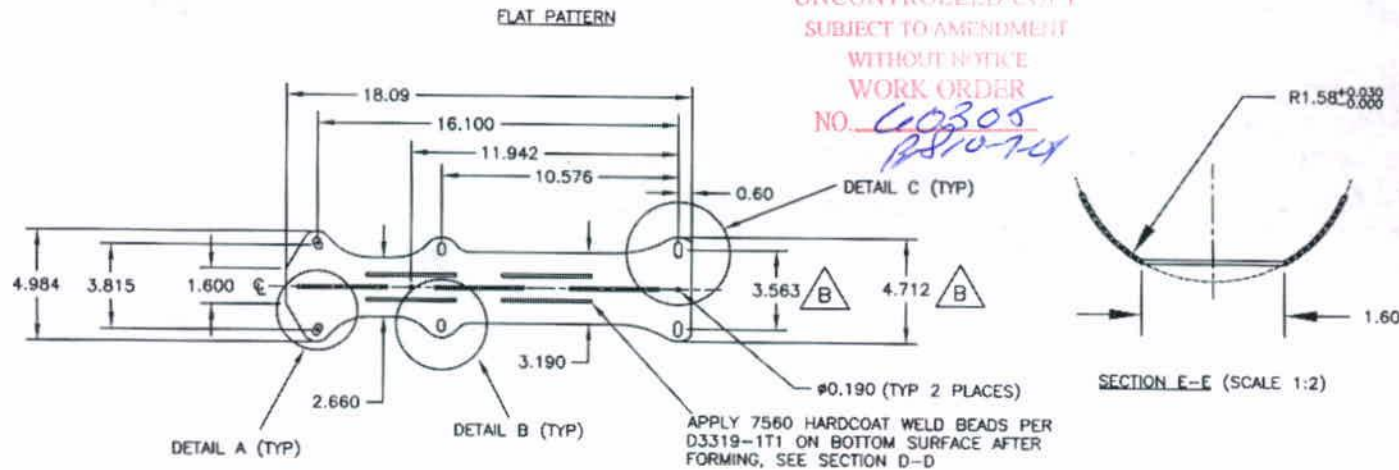
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *60305*  
*PS10-14*

**DART**



#### D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH1	PH1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	05.06.06	D3319
		TITLE
		WEARPLATE
		SCALE
		1:8
		REV. B
		SHEET 1 OF 5
		WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		NEW ISSUE
		04.09.24
		05.06.06
		05.06.06

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RELEASED  
05.09.30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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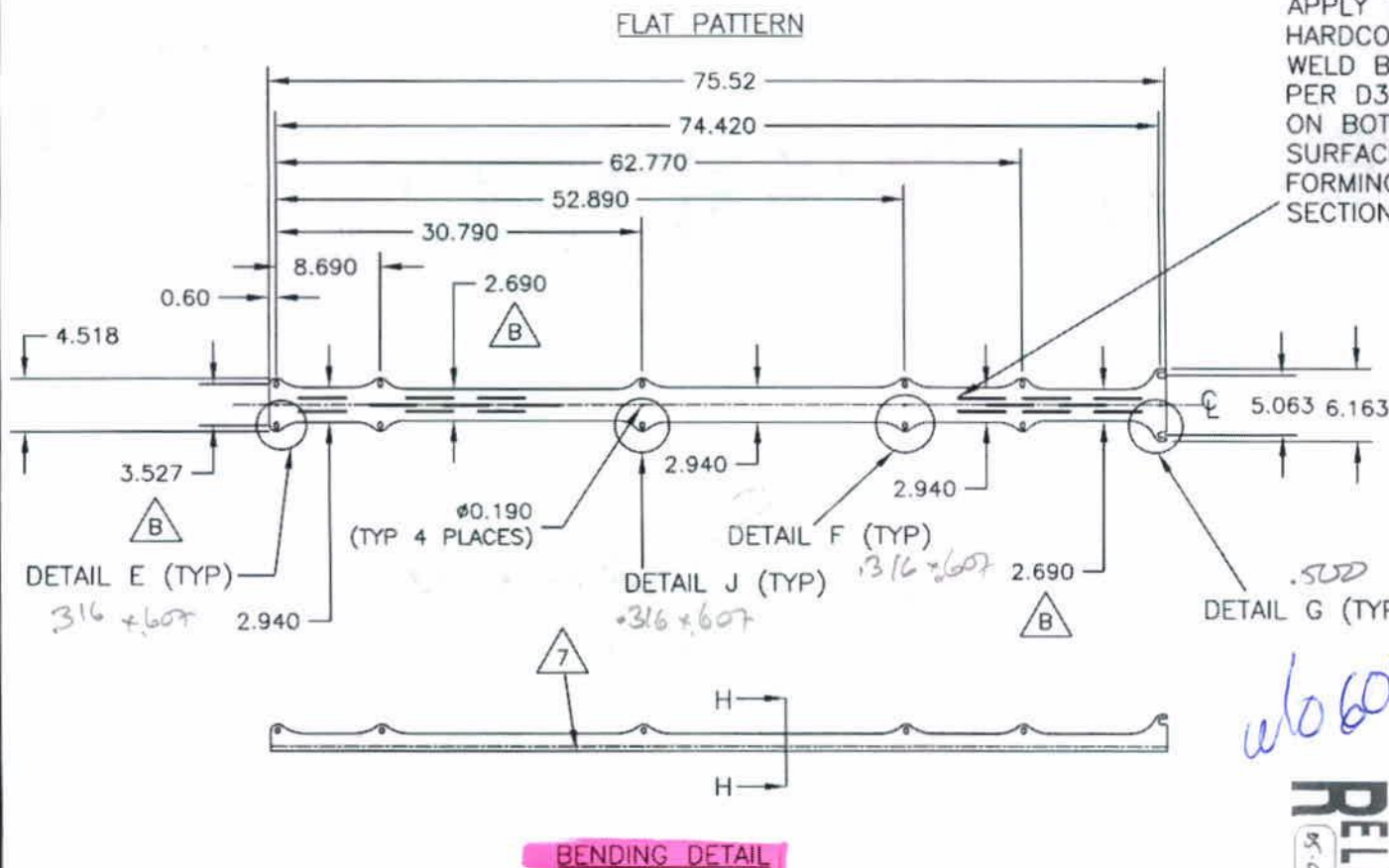
**NOTE:** Date & initial all entries



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
#		HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 2 OF 5
		SCALE
		1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



RELEASED  
05-01-30

#### D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

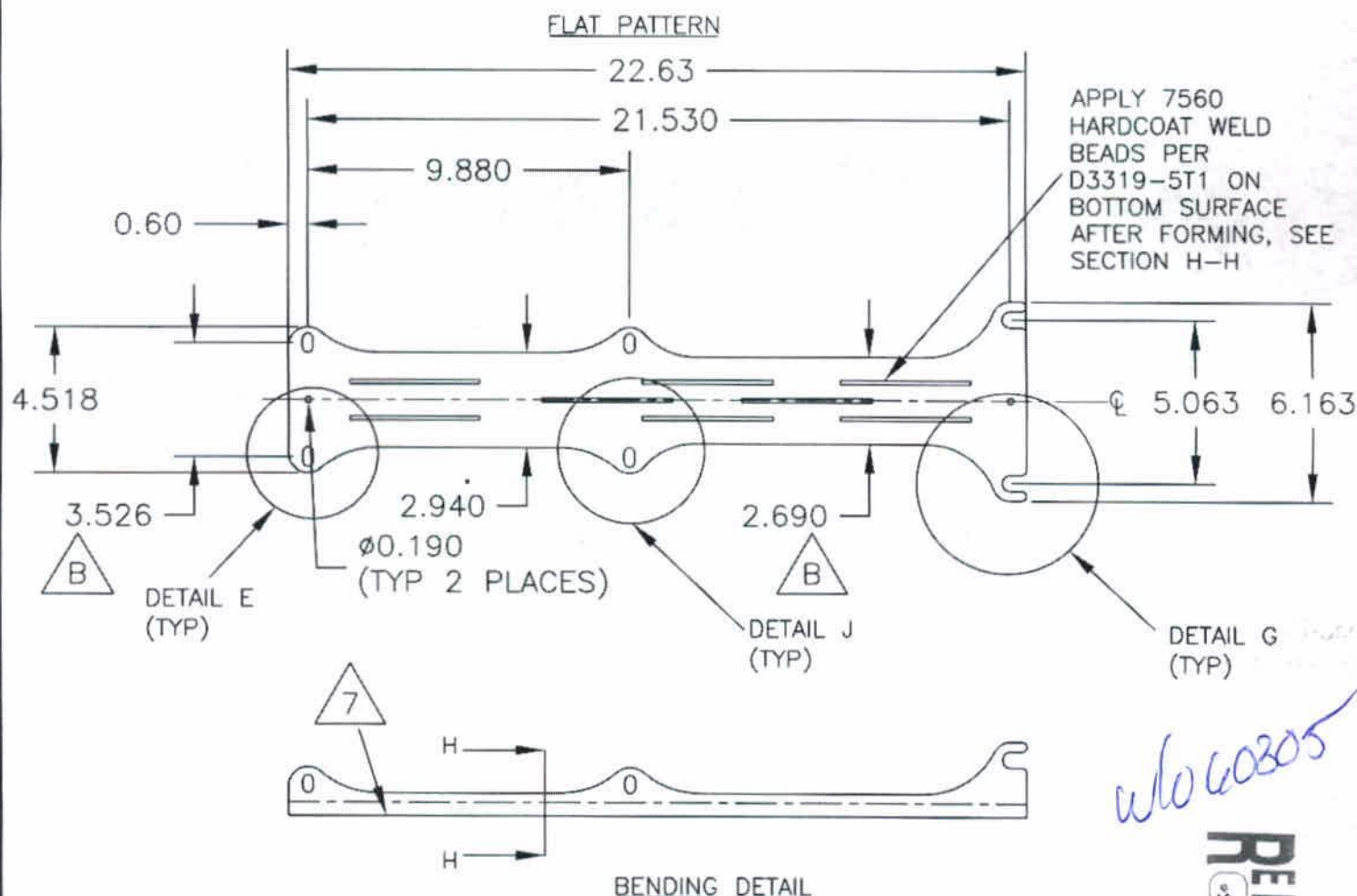
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
041	044			
CHECKED	APPROVED	DRAWING NO.	REV. B	
#	#	D3319	SHEET 3 OF 5	
DATE	TITLE		SCALE	
05.06.06	WEARPLATE		1:5	

et



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
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- 6) WELD PER DART QSI 004
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FOR PRODUCT ELIGIBILITY SEE PDA05-18"

05-09-30

who 60305

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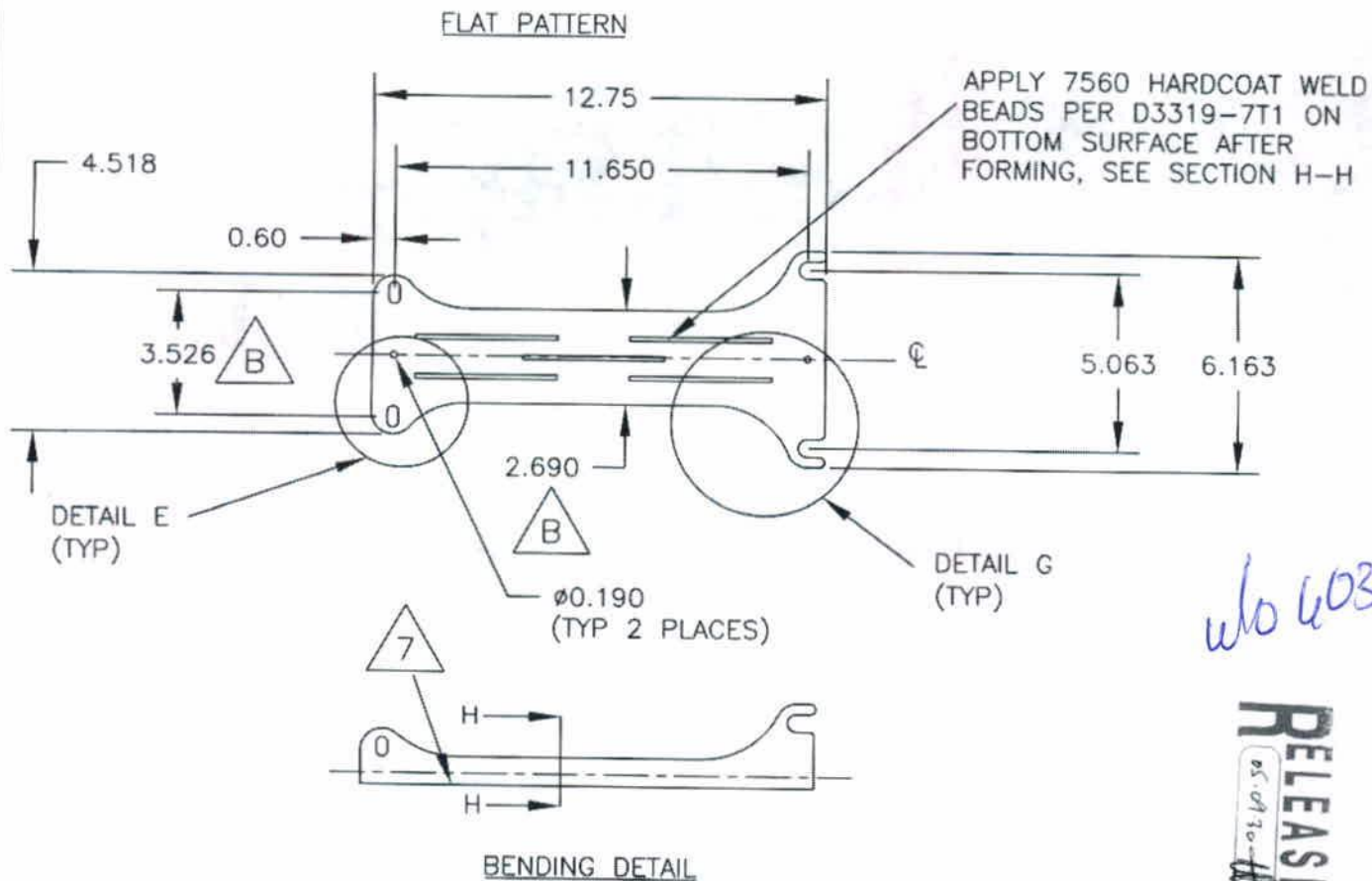


**DART**

DESIGN		DRAWN BY		DART AEROSPACE LTD	
PH		PH		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
		D3319		SHEET 4 OF 5	
DATE		TITLE		SCALE	
05.06.06		WEARPLATE		1:5	

who 40305

05-09-70



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
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- 6) WELD PER DART QSI 004
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

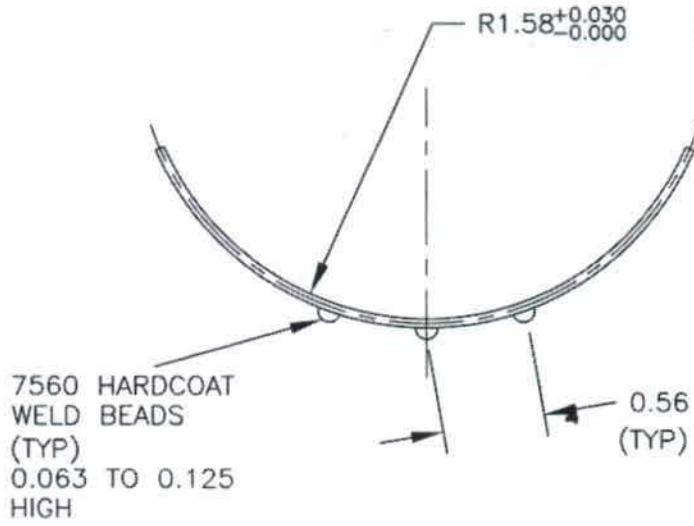
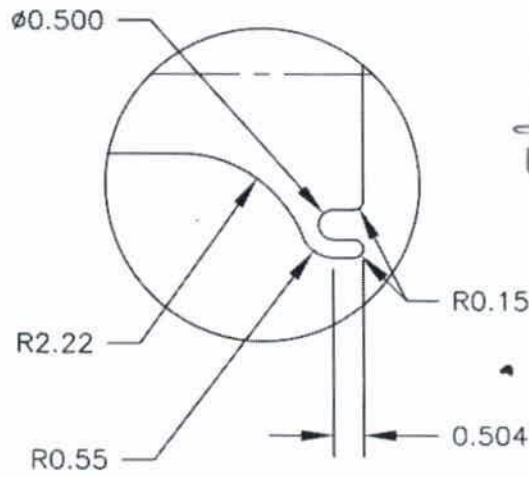
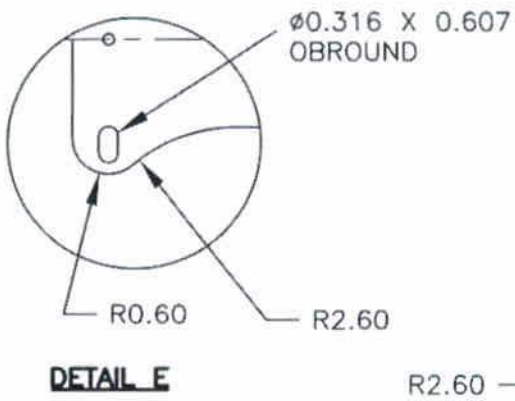
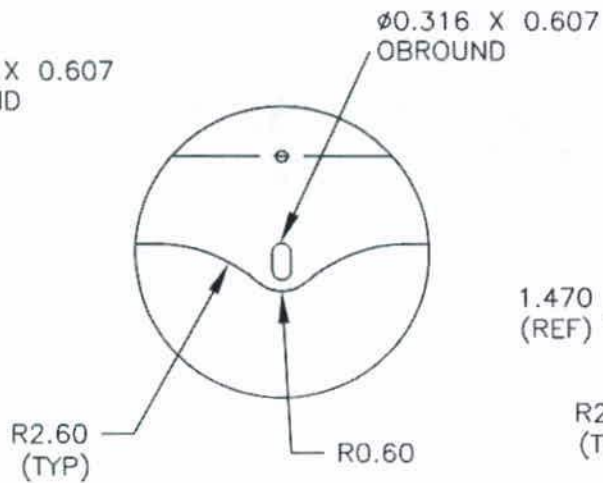
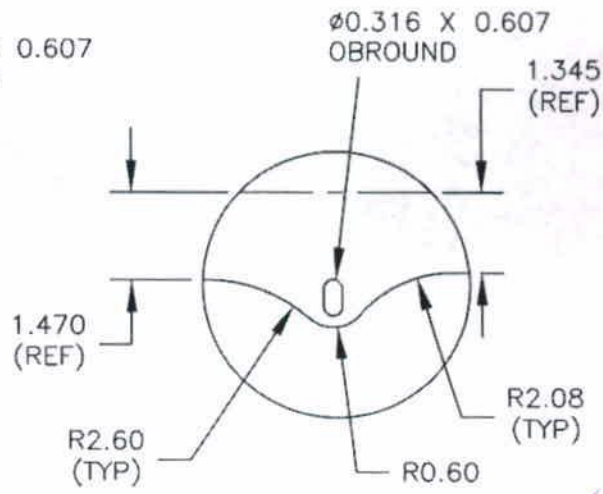
**NOTE:** Date & initial all entries

**DART**

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3319	SHEET 5 OF 5
		SCALE	1:3	

**RELEASED**  
05 09 30 11

*w/o 40205*



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries